#### Work Order ID 109644 \*109644\* Friday, November 22, 2013 11:35:30 AM Item ID: D4134-041 Accept \*N900040100\* Setup Start **Revision ID:** Wearplate, LH Aft Item Name: Start Qty: 2.00 Start Date: 11/22/2013 **Cust Item ID: Required Date:** 11/29/2013 Req'd Qty: 2.00 **Customer:** Reference: Run Process Plan: Approvals: Date: Stop QC: Date: SPC (Y/N): Date: Sequence ID/ Operation Reject Set Up/ Tool ID Tool # Plan Accept Reject Insp. Work Center ID Description **Run Hours** Code **Qty Qty** Number Stamp Draw Nbr **Revision Nbr** D4134 В 100 0.00 FLOW WATER JET \*100\* Waterjet 0.00 Memo FLOW CNC Wateriet 1-Cut D4134 as per Dwg D4134 Dwg Rev:\_ Prog Rev: 2-Deburr if necessary QC2-Inspect parts off machine FAI/FAIB 0.00 0.00 Memo Quality Control

120

Quality Control

QC8- Inspect parts - second check

Memo

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ı	NUR	 res	/	NC

# **WORK ORDER NON-CONFORMANCE / UPDATE**

DQA: Date: 13/12/19	
QA Closed Date://12/18	

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Work Orde	Work Order: 109644 Disposition									AGAINST D	EPARTMENT,	17'	
Part N	io. <u>'</u>	D413	34-0	,		Us Work Order U	Therm	Skid-tube Machining noforming Large Fab	Crosstube Small Fab Finishing Composite	-	Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other	
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Cause		Date	Step	Qty	C	or Non-conformanc	e C	hief Eng	Desc	cription	Qate	Verification	QC Inspector
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Friday, November 22, 2013 11:35:30 AM

Item ID: D4134-041 Revision ID: Wearplate, LH Aft Item Name: Start Date: 11/22/2013 Start Qty: 2.00 Required Date: 11/29/2013 **Req'd Qty: 2.00** Reference:

**Cust Item ID: Customer:** 

Tool ID

**Process Plan:** Approvals:

QC:

Date: Date:

Tooling: SPC (Y/N):

Accept

Date: Date:

Tool#

Plan

Code

\*N900040100\*

Stop

Reject

Setup Start

Reject

Oty

Run

Number Stamp

Insp.

Sequence.ID/ Work Center ID

\*120\* Brake NC Brake NC

**Operation** Description Form as per dwg

NC BRAKE

Memo

Set Up/ **Run Hours** 0.00

DAS 30 9-89

\*140\*

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

0.00

DAS 27

Accept

Oty

Weld per dwg A/R Hardcoat S.S. Batch 1241340.00 > 228 Large Fab

1- Form using D7964 Die as per Dwg D4134

\*150\* Large Fab

150

Memo Large Fab

0.00

Weld hard surface using DT as per QSI 004 and Dwg D4134

											DQA:	Date	:		
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Nork Orde	r:					DISPOSITION			AGAIN:	ST DE	PARTMENT/PROCESS				
Part N NCR N	_					Rework Scrap Use-as-is Work Order Update	Skid-tube Crosstub  Machining Small Fa  Thermoforming Finishin  Large Fab Composit				4	Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other		
Root Cause		Date	Step	Qty		ption of work order update	1	nitial ief Eng	Action Description		Sign & Date	Verification	QC Inspector		
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	Inspection Strip in Tube Cut Too Short				-	Misread	i	L	Power Loss/	Surge	Other				
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Friday, Novemb	per 22, 2013	11:35:30 AM		1175	7()44						
Item ID: Revision ID: Item Name:	D4134-041 Wearplate, LI	ł Aft		Accept	*N90004	<b>I</b> 0100	)* s	etup Start Stop	*N:	S1*	1
Start Date: Required Date Reference:	11/22/2013	Start Qty: 2.00 Req'd Qty: 2.00	*2* *2*		Cust Item ID: Customer:				IV.	. 7/	
Approvals:	Process Pla	<b>in:</b>	Date:	Tooling: SPC (Y/N):	Date:		R	un Start Stop	1/7	R1* R2*	
Sequence ID/ Work Center I	D	Operation Description		Set Up/ Run Hours	Tool ID Too	ol# Plan Code	Accept Qty		Reject Number	Insp. Stamp	
*160 *160* QC Quality Control		QC10- Inspect visual pe	er QSI004- ground welds	0.00			Q	)13	11.36		<b>DAS</b> <b>9</b> 9-89
170 *170*		QC5- Inspect part comp	oleteness to step on W/O	0.00			(*)	V 15	-ll-J6		DAS 9 - 9-89
QC Quality Control		Мето		0.00				/)\ <b>-</b>	-11. A. O.		. 5-08
180 *180*		Grey Sandtex(Ref:4.3.5	76/	0.00			2	d u	?.ir. <b>24</b>	, DA	8
Powder Coating		Memo START TII OVEN TEI FINISH TII	MPERATURE:	0.00				\$_1E	)	34 9-8	) 9

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Work Orde	er: _					DISPOSITION	AGAINST DEPARTMENT/PROCESS  Skid-tube Crosstube Water Jet Engineering							
Part N	_					Rework Scrap Use-as-is Work Order Update	The	Skid-tube Machining Machining Moforming Large Fab	Crosstube Small Fab Finishing Composite	Il Fab Prod. Eng. Coor. Quality shing Rec/Store/Packaging Other				
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	Turning Sequence					Finish	Out of Sequence							
1	Wave/Twist in Tube				1	Folio	Outside Dimensions							

Quality Control

\*109644\*

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Friday, November 22, 2013 11:35:30 AM

D4134-041 Item ID: Accept \*N900040100\* Setup Start **Revision ID:** Item Name: Wearplate, LH Aft **Start Date:** 11/22/2013 Start Qty: 2.00 **Cust Item ID: Required Date:** 11/29/2013 **Req'd Qty:** 2.00 **Customer:** Reference: Run **Process Plan:** Approvals: Date: **Tooling:** Date: Stop QC: SPC (Y/N): Date: Date: Accept Sequence ID/ Operation Set Up/ Tool ID Tool# Plan Reject Reject Insp. Work Center ID Description **Run Hours** Code Qty **Qty** Number Stamp QC3- Inspect Part Finish 0.00 \*10**0**\* Memo Quality Control 0.00 0.00 Small Fab Memo Small Fab 1- Bond D4134-3 gasket to inner surface of wearplate using a thin layer of 3M 1300/1300L scotch grip adhesive Batch: 1473 QC5- Inspect part completeness to step on W/O \*210\* Memo

NCD.	Voc	,	Nio
NCR:	Yes	/	NO

												DQA:	Date	2:		
NCR:	Yes	/ No				WORK	ORDER NON-	COI	NFORM	MANCE / UP	DATE	QA Closed:	Date	2:	•	
Vork Ord	er:						DISPOSITION				AGAINST D	EPARTMENT				
Part I	No.					Wor	Rework Skid-tube Crosstube Scrap Machining Small Fab Use-as-is Thermoforming Finishing rk Order Update Large Fab Composite					Pro Rec/Sto	Engineering Quality Other			
Root					Desc	ription of wo	ork order update	I	nitial	Ac	tion	Sign &				
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		Bending Centre Not Concentric to O/S Cracks Crushed/Crimped Cuffs Heat Treat Inspection Strip in Tube Ripples in Bend Torque Waves in Extrusion				Bend BOM/Rou Broken/D Burrs Contamina Countersi Cut Too Sh Drill Hole Drawing	amaged ation ink ort		Instruct Mainte Mislabe Misread Offset	on Incomplete ions Incomplete/ nance led	'Unclear	Ovalized Over/Under Part Incorre Part Lost/M Part Moved Positioned V Power Loss/	ct issing Vrong	Pressure/Forced Temperature/Cure Weld Wrong Stock Pulled Other	-	
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Outside Dimensions

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Wave/Twist in Tube

Folio

\*109644\*

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Friday, November 22, 2013 11:35:30 AM Item ID: D4134-041 \*N900040100\* Accept Setup Start Revision ID: Item Name: Wearplate, LH Aft Start Date: Start Qty: 2.00 11/22/2013 **Cust Item ID:** \*2\* Req'd Qty: 2.00 **Required Date:** 11/29/2013 **Customer:** Reference: Run Process Plan: Approvals: Date: Tooling: Date: Stop QC: SPC (Y/N): Date: Date: Sequence ID/ Operation Tool ID Tool# Plan Reject Set Up/ Accept Reject Insp. Work Center ID Description Qty **Run Hours** Code **Qty** Number Stamp 220 Identify as per dwg & Stock Location: 0.00 13/4/28 2 Packaging \*220\* Pt 500 0.00 Packaging Memo MUS 13-11-21 MUS 13-11-21 Packaging QC21- Final Inspection - Work Order Release 0.00 0.00 Memo Quality Control

DAS 32

NCR:	Yes	/	No
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DQA:

Date:

NCR: Ye	s / No				WORK ORDER NON-C	LONFO	ORIV	HANCE / UPL	JAIL	QA Closed:	Date:			
Work Order:					DISPOSITION	5.4			AGAINST DE	PARTMENT	PROCESS			
Part No					Rework Scrap		N	Skid-tube Machining	Crosstube Small Fab	4	Water Jet d. Eng. Coor.	Engineering Quality		
NCR No					Use-as-is Work Order Update	]   TI		Large Fab	Finishing Composite					
Root				Descri	ption of work order update	Initi	ial	Act	ion	Sign &				
Cause	Date	Step	Qty	(	or Non-conformance	Chief	Eng	Descr	ription	Date	Verification	QC Inspector		
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·	Inspection Strip in Tube Cut Too Short				₫	<b>—</b>	isread	1	L	Power Loss/	Surge	Other		
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	Torque Waves in Extrusion Drawing					Out of Calibration								
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	Wave/Tv	vist in Tu	he	l l	Folio	I lou	itside	Dimensions						

Work Order ID:

109644

Parent Item:

D4134-041

Parent Item Name:

Wearplate, LH Aft

Comments:

IPP Rev:A 10.06.25 new issue DD verf:EC REV.B DD verf:EC

**Start Date: 11/22/2013** 

**Required Date:** 11/29/2013

Page 1

Start Qty: 2.00

Required Qty: 2.00

	KLV.B DD Vell.EC	<b>,</b>											
Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
* D4134-3		Manufactured	No			200	Each	0.0000	(m) 1	2	13/	//28	DAS 36
Gasket  M304S18GA	e Totalisas	Purchased	No		-	100	5/0/6 sf	298.8774	1.5825	4	A.	13.	989
25304/316 .050 Sheet										A CALL OF STATE OF STATE OF	~~ ~ <i>/ W</i>	. m <u>.</u> 1.00 m.	m: 1 mm 6 4

IPP Rev:B 10.11.22 AS PER DWG

Location	Loc Qty	Loc Code	
MAT019	146.95001		
117188	3.88		
117766	5		
120604	5		
122325	3	•	
123155	3		
124572	0.00001		·
M126647	127.07		
MAT020	151.92742		
120243	0.928		
121626	1.529894		
124029	84.046526		
M126098	65.423		

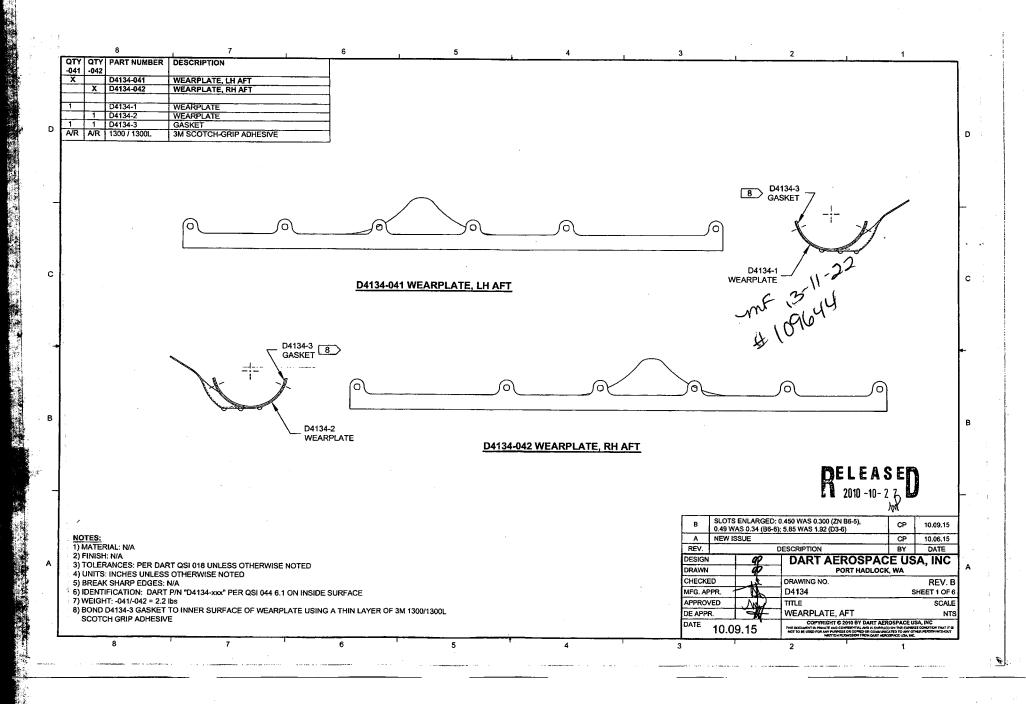
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1100	V	,	A1 -
NCR:	Yes	1	No

#### **WORK ORDER NON-CONFORMANCE / UPDATE**

DQA: \_\_\_\_\_Date: \_\_\_\_

NCR.	es / 140				WORK ONDER 14014-		WINITEL / OI	DAIL	QA Closed:	Dat	e:	
Work Orde	r:				DISPOSITION			AGAINST DE	PARTMENT	/PROCESS		
Part N					Rework Scrap	]	Skid-tube Machining rmoforming	Crosstube Small Fab Finishing	-i	Water Jet d. Eng. Coor.	Engineering Quality	
NCR N	0				Use-as-is Work Order Update							
Root				Descri	ption of work order update	Initial	Ad	ction	Sign &			
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	Crushed/	Crimped			Burrs	Instr	ictions Incomplete	/Unclear	Part Lost/M	issing	Wrong Stock Pulled	
	Cuffs				Contamination	Mair	itenance		Part Moved			
	Heat Trea	at			Countersink	Misla	beled		Positioned \	Wrong .		
	Inspectio	n Strip in	Tube		Cut Too Short	Misre	ead		Power Loss/	'Surge	Other	
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							Outside Dimensions					

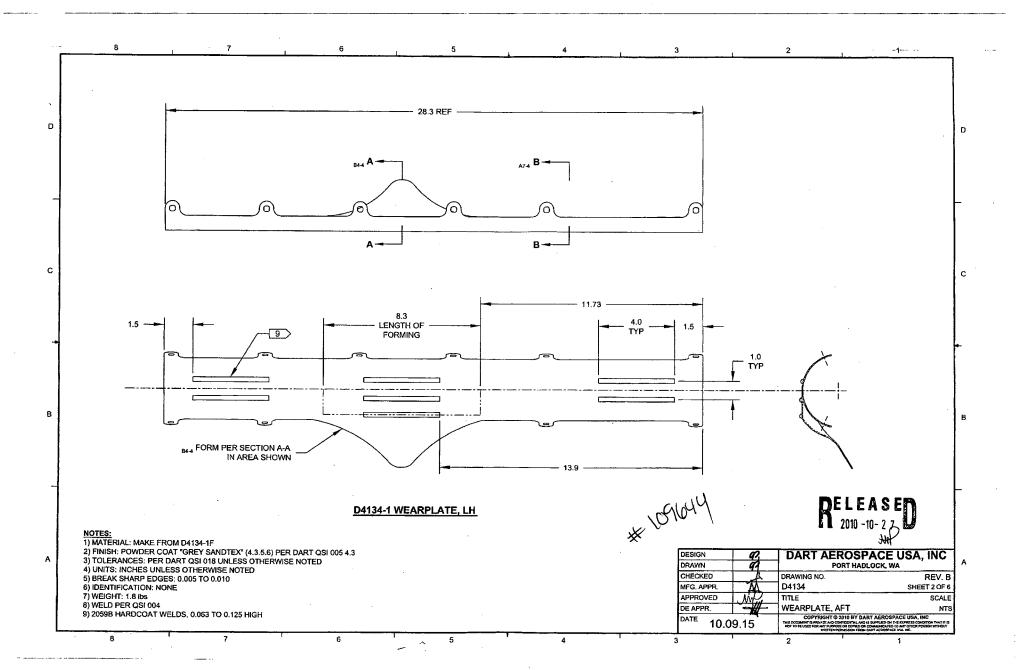


DQA:		Date:	
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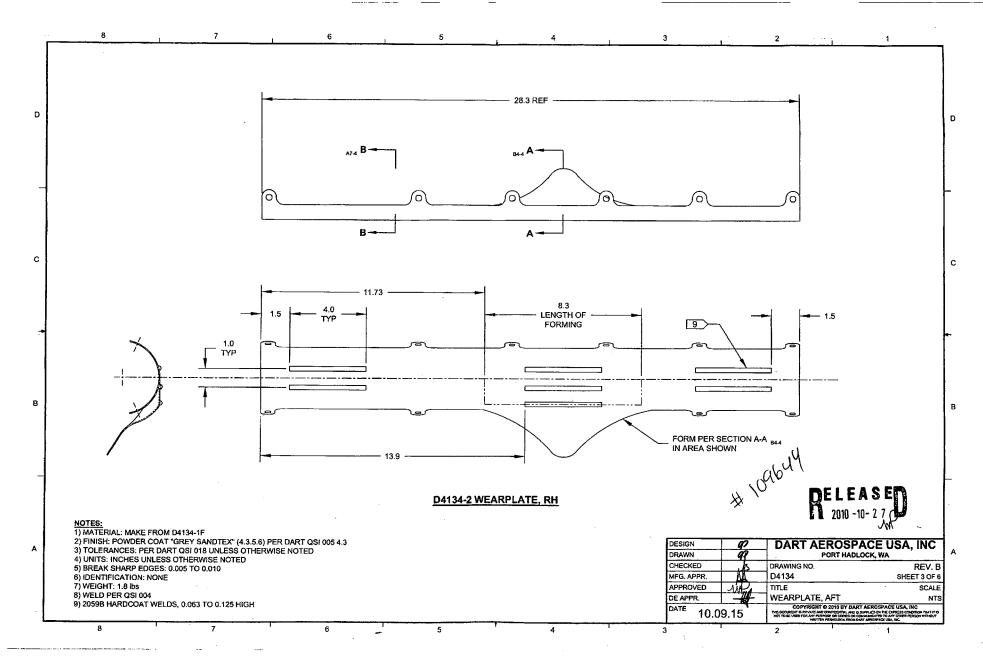
#### **WORK ORDER NON-CONFORMANCE / UPDATE**

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Work Orde	r·				DISPOSITION			AGAINST DE	PARTMENT,	/PROCESS	
Part No					Rework Scrap	]	Skid-tube Crosstube  Machining Small Fab		Pro	Water Jet d. Eng. Coor.	Engineering Quality
NCR N					Use-as-is Work Order Update	The	rmoforming Large Fab	Finishing Composite	Rec/Sto	Other	
Root				Descri	ption of work order update	Initial		Action	Sign &		
Cause	Date	Step	Qty		or Non-conformance	Chief E	ng Des	scription	Date	Verification	QC Inspector
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Ripples in Bend					Drill Holes	Offse				-	
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Turning Sequence Finis					Finish	Out of Sequence					
	Wave/Tv	vist in Tu	be		Folio	Outs	ide Dimensions				·



		DQA:	Date:	
NCR· Yes / No	WORK ORDER NON-CONFORMANCE / UPDATE			

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Work Orde	 r:				DISPOSITION				AGAINST DI	EPARTMENT	/PROCESS	
Part N	o				Rework Scrap Use-as-is Work Order Update	Scrap Machining Small Fab e-as-is Thermoforming Finishing			Pro Rec/Sto	Engineering Quality Other		
Root				Descri	ption of work order update	Ini	itial	Ac	ction	Sign &		
Cause	Date	Step	Qty		or Non-conformance		f Eng	Desc	ription	Date	Verification	n QC Inspector
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	Turning Sequence Finish					Out of Sequence						
i i	Wave/Twist in Tube Folio						Dutside	Dimensions		_		

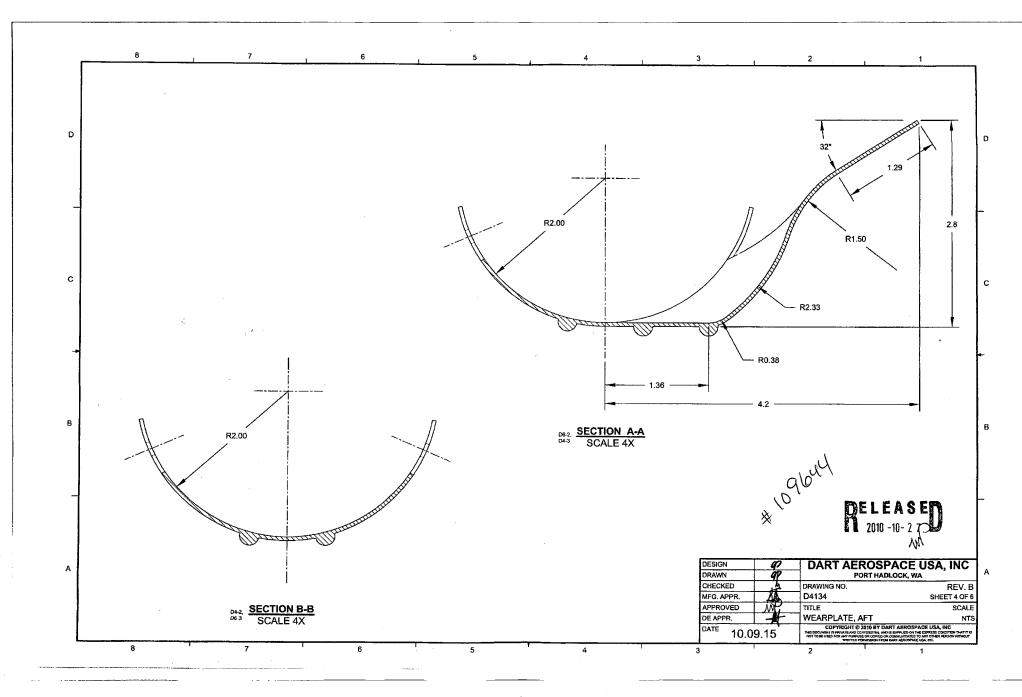


NCR:	Yes	/	No

## **WORK ORDER NON-CONFORMANCE / UPDATE**

DQA: \_\_\_\_\_Date: \_\_\_\_\_

NCK: Ye	QA Closed: Date:											
Work Order	· ·		· · · · · · · · · · · · · · · · · · ·		DISPOSITION				AGAINST DE	PARTMENT	PROCESS	
Part No					Rework Scrap	<b>∃</b> [		Skid-tube Crosstube Water Jet En  Machining Small Fab Prod. Eng. Coor.			Engineering Quality	
NCR No					Use-as-is Work Order Update		Thermoforming Finishing Rec/Store/Packaging Supplier					Other
Root	1			Descr	iption of work order update	lni	itial	Act	tion	Sign &		
Cause	Date	Step	Qty		or Non-conformance	Chie	ef Eng	Descr	ription	Date	Verification	n QC Inspector
oc/Data												
quip/Tooling												
perator											!	
1aterial	_											
etup	_											
ther	_											
rocess												
upplier	_											
raining	_											
napproved					<del></del>					J		
						FAULT	CATE	JORY				
Landin F	_				General		Grain			Ovalized	Γ	Pressure/Forced
-	Bending			,,	Bend	$\vdash$			<u> </u>	Over/Under	toloranco	Temperature/Cure
-	→	lot Conce	ntric to (	<sup>3/5</sup>  -	BOM/Route		lardwa	re on incomplete	<u> </u>	Part Incorre	+	Weld
-	Cracks	/C=:===========		-	Broken/Damaged Burrs	-	-	ions Incomplete/	Uncloar	Part Lost/M		Wrong Stock Pulled
-	Cuffs	/Crimped		-	Contamination			nance	Unclear –	Part Moved	133111g	Wrong Stock i uned
	_			-	Countersink	-	Vislabe		F	Positioned V	Vrong	
ŀ	Heat Tre	eac on Strip ir	Tuha	-	Cut Too Short	$\vdash$	Viisiabe Misreac			Power Loss/		Other
}	Ripples		itube	 	Drill Holes	<b> </b>	Offset	1	L	7. 5 2033/		
}		Waves in I	Evtrucio	<u>,</u>	Drawing	$\vdash$		Calibration			<u> </u>	
<u> </u>		Sequence		''  -	Finish	—		Sequence				
ŀ		wist in Tu		H	Folio	-		Dimensions				
	144046/1	** .5 t 11 t 1 U	~~		1							



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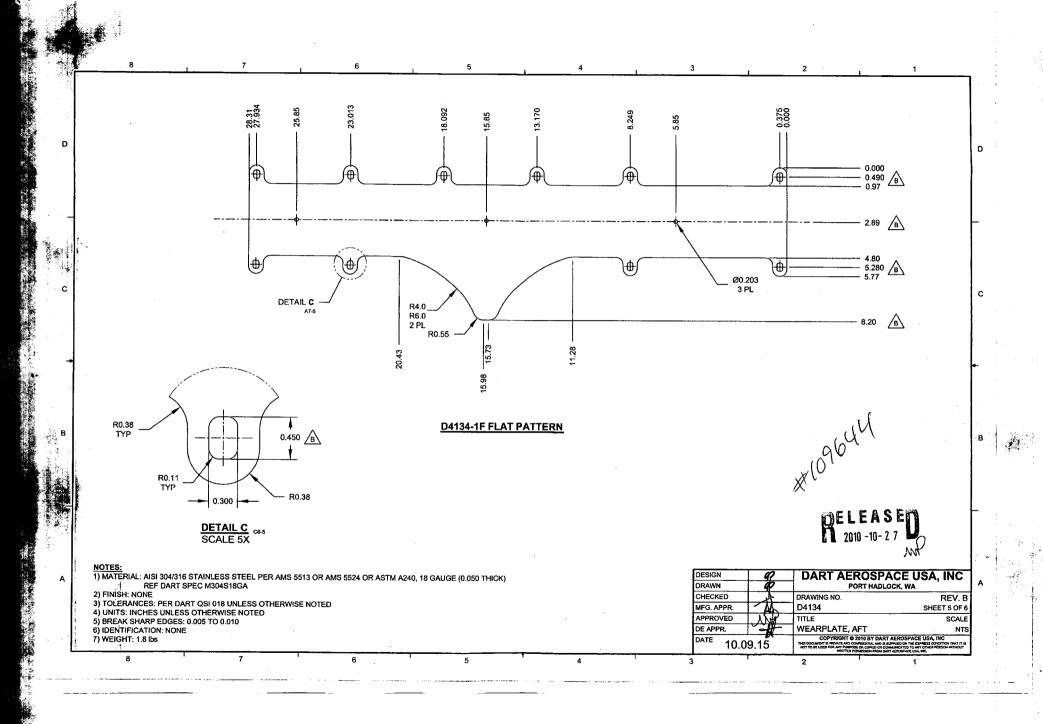
										DQA:	Date	:
NCR: Y	es / No				WORK ORDER NON-	CON	FORN	MANCE / UPDATE			•	
							=			QA Closed:	Date	:
Work Orde	r:				DISPOSITION		AGAINST DEPARTMENT/PROCESS					
Part N					Rework Skid-tube Scrap Machining Use-as-is Thermoforming			Machining Small Smolorming Finis	Fab	Water Jet Engineering Prod. Eng. Coor. Quality Rec/Store/Packaging Other		
NCR N	0	· · · · · · · · · · · · · · · · · · ·			Work Order Update Large Fab Comp			Large Fab Compo	osite		Supplier	
Root				Descr	iption of work order update	ln	itial	Action	•	Sign &		
Cause	Date	Step	Qty		or Non-conformance	Chie	ef Eng	Description		Date	Verification	QC Inspector
oc/Data						Ī	_					
quip/Tooling												
Operator												
<b>Material</b>												
etup												
Other												
Process												
Supplier												
raining												
Jnapproved			<u> </u>	1								
						FAULT	CATE	GORY			i	
Landir	ng Gear			_	General				_	7	· ·	<b>-</b>
]	Bending			_	Bend	$\boldsymbol{\vdash}$	Grain		<u> </u>	Ovalized	ļ.	Pressure/Forced
		lot Conce	ntric to	o/s	BOM/Route	-	Hardwa		<u> </u>	Over/Under		Temperature/Cure
	Cracks			_	Broken/Damaged	$\vdash$	•	on Incomplete		Part Incorre	H	Weld
,		I/Crimped Burrs				-⊢		ions Incomplete/Unclear	_	Part Lost/Mi	issing	Wrong Stock Pulled
	Cuffs			ļ	Contamination	$\vdash$		enance		Part Moved		
	Heat Tre				Countersink	$\vdash$	Mislabe			Positioned V		٦
Inspection Strip in Tube					Cut Too Short	$\vdash$	Misread	d	L	Power Loss/	Surge	Other
	Ripples in Bend Drill Holes						Offset					· · ·
	<b>—</b>	Waves in		n _	Drawing	$\vdash$		Calibration				
	Turning Sequence Finish Out of Sequence											

Outside Dimensions

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Wave/Twist in Tube

Folio



		DQA:	Date:	
NCD: Voc / No	WORK ORDER NON-CONFORMANCE / LIDUATE			

NCR: Yes / No WORK ORDER NON-CONFORMANCE / UPDATE													
						<b>Y</b>		1			QA Closed:	Date	e:
Work Ord	er.					DISPOSITION				AGAINST DE	PARTMENT	PROCESS	
Part f	. No.					Rework Scrap Use-as-is Work Order Update	crap Machining Small Fab as-is Thermoforming Finishing			Small Fab Finishing	Pro Rec/Stor	Engineering Quality Other	
Doct	_				Dosori	ntion of work order undate		nitial	Act	tion	Sign &		
Root Cause		Date	Step	Qty		ption of work order update or Non-conformance		ief Eng		ription	Date	Verification	QC Inspector
Doc/Data	П	Date	Step	Qty		or Non-comormance	-	ier Eng	Desci	прион	Date	Vermeation	Qe mspector
Equip/Tooling	H												
Operator	Н		1										
Material	H						1						
Setup	$\vdash$		ļ				1						
Other	$\vdash$												
Process	H												
Supplier	П		Ì										
Training	П												
Unapproved	П												
				A		F	AUL	T CATE	GORY				
Landi	ing (	Gear				General						_	
		Bending				Bend		Grain			Ovalized		Pressure/Forced
		Centre N	ot Conce	ntric to	o/s	BOM/Route		Hardwa	ire		Over/Under	tolerance	Temperature/Cure
		Cracks				Broken/Damaged	L	Inspect	ion Incomplete		Part Incorre	ct	Weld
İ	L	Crushed/Crimped Burrs						Instruct	tions Incomplete/	Unclear	Part Lost/Mi	ssing	Wrong Stock Pulled
	Cuffs					Contamination		Mainte	enance		Part Moved		•
	$\perp$	Heat Trea				Countersink		Mislabe		<u> </u>	Positioned V		
Inspection Strip in Tube						Cut Too Short		Misrea	d	L	Power Loss/	Surge	Other
		Ripples in				Drill Holes		Offset					
	Torque Waves in Extrusion Drawing							Out of Calibration					
	Turning Sequence Finish							Out of Sequence					

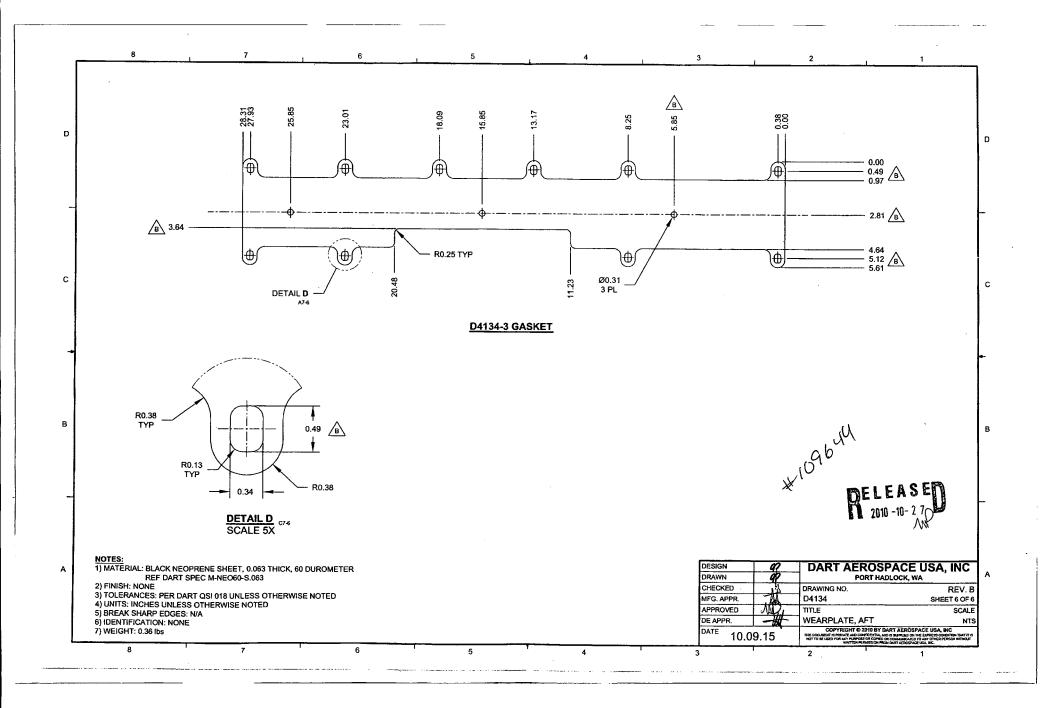
Outside Dimensions

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Turning Sequence

Wave/Twist in Tube

Finish Folio



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	The Sacration		
	7 (1) 20 (2) 21 (3) 23 (4)		
di es			

DART AEROSPACE LTD	Work Order:	109644
Description: Wearplate LH AFT	Part Number:	4134-041
Inspection Dwg: 4124 Rev: B		Page 1 of 1

## FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
,375"	+1- ,010	,375			<b>V</b>	JKW-01
,585"	+1- ,010	, 585	_		>	
8.249"	+1- ,010	8,249			Τ	JKM-06
13.170"	+/010	13.176			Τ	
15.85"	+1- ,030	18.85	_		T	
18.092	4/010	18.092			T	
	41- ,010	23.013			7	
	+1- 1036	25.85			7	
27.934"	+1- 1010	27.934	_	,	T	
28.31"	+1- 1036	28.31				
.490"	41- 1010	,490	-		V	
,97"	රුදියා	.97			<b>V</b>	
2.89"	1036	2.89			<b>V</b>	
4.80	. 630	4.80	-		V	
5.280	1010	5.281	-		V	
5,77"	,030	6.78	_		V	
8.20"	,ల్ర3ల	8.20			<u> </u>	
11.28"	, ৩3৩	11.28			7	
15,73"	. 030	15.73	_		7	
15.98"	. 030	15.98	-		Τ	
20.43"	, ცვი	20.43			Τ	
	1,005/-,001	,203			٧	
.300 x,450"		,248×450		•	Υ	

Measured by:	Audited by:	ShP	Preliminary Approval:	
Date: 13.11.00	Date:	13 11 22	Date:	

Rev	Date	Change	Revised by	Approved
E	10.04.14	Added preliminary approval	KJ	

\$ 10.0¢.15